

5/23

DART AEROSPACE LTD	Work Order:	23248
Description: Saddle billet	Part Number:	D6101-013
Drawing: D6101 Rev. A	Qty:	12

Step	Location	Procedure	By	Date	qty
1	EXPEDITING	Open W/O	RF	05.05.11	12
2	PURCHASING	Issue P/O: 2008035 a) Description: Aluminum billet b) 10.100" x 8.250" x 2.50" thick (+0.030 / -0.000) c) Tolerance on all dimensions are +0.030"/-0.000" d) Grain direction along 10.100" length e) Material: 7075-T7351 (QQ-A-250/12) Material certification required	U	05.08.12	12
3	RECEIVING	Receive & Inspect for transit damage Ensure certification are attached	CL	05/05/25	12
4	QC	Inspect level 6 Check certification to Dwg D6101 for compliance	CR	05/06/11	12
5	STORES	Identify & stock	EN	05/05/25	12
6	EXPEDITING	Close W/O 136.21 Cost / part 142.79	RF	05.06.14 Inspect Level 21	12

Rev	Date	Change	Revised By	Approved
A	01.05.04	New Issue	EC	EC

RELEASED

01.05.16

RF
03.06.05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

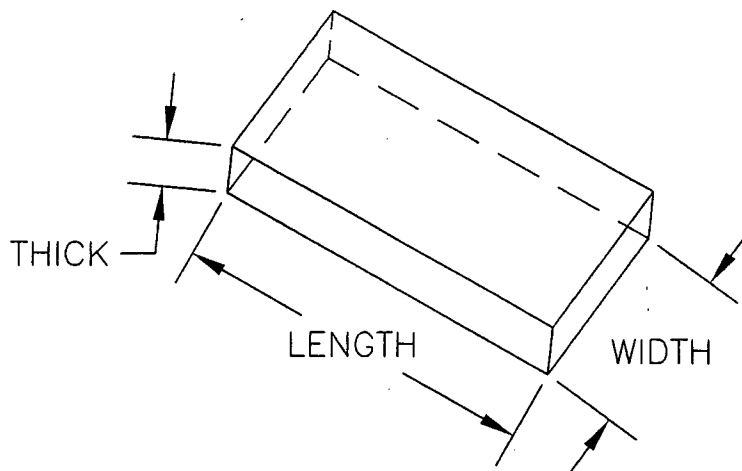
QA: N/C Closed: _____ Date: _____



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>JS</i>	DRAWING NO. D6101	Rev. A SHEET 1 OF 1
DATE 01.03.30		TITLE SADDLE BILLET, 7075	SCALE NTS
A	01.03.30	NEW ISSUE	

SPECIFICATION CONTROL DRAWING

RELEASED
01.04.23 *#*



PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6101-001	7075-T7351 (QQ-A-250/12)	6.000	6.250	2.000	Along 6.000 Length
D6101-003	7075-T7351 (QQ-A-250/12)	7.875	6.250	2.000	Along 7.875 Length
D6101-005	7075-T7351 (QQ-A-250/12)	5.000	8.250	2.500	Along 5.000 Length
D6101-007	7075-T7351 (QQ-A-250/12)	7.750	8.250	2.500	Along 7.750 Length
D6101-009	7075-T7351 (QQ-A-250/12)	8.700	8.250	2.500	Along 8.700 Length
D6101-011	7075-T7351 (QQ-A-250/12)	9.700	8.250	2.500	Along 9.700 Length
D6101-013	7075-T7351 (QQ-A-250/12)	10.100	8.250	2.500	Along 10.100 Length
					UNCONTROLLED COPY
					SUBJECT TO AMENDMENT
					WITHOUT NOTICE
					WORK ORDER

NO. 23248

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

May 09, 2005
02:16 pm

Work Order No : 0023248
Project Name : D6101-013
Project For : WK523
Work Order Type : Main
Main WO Number :
House Part Number : D6101-013
Description : Saddle billet
Manufactured : Yes
Amount Req'd : 12
Amount Done : 0
Start Date : 05-09-05
Est Finish Date : 06-05-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA

DAVENPORT WORKS

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

Per
Mark J. Vrabec

Mark J. Vrabec
Director of Manufacturing Davenport Works

Kenton P. Young

Kenton P. Young
Quality Assurance Manager

384290

Ship Date

2005-04-02

P.O. No./Govt Contract No.

CE0785

91023

B.L. No.

73009

Invoice No.

04423

Customer

C&B-WALLINGFORD

Ship From: RIVERDALE, IA.

Alcoa No. Item

DS-86515-1

Page 1

Ship To: COPPER & BRASS SALES INC
WALLINGFORD BRANCH
5 STERLING DRIVE
WALLINGFORD, CT 06492

Item Description

2.500 IN TK X 47.75 IN W X 164.5 IN LN (N) A/T 7075-
T7351 RECTANGLE MILL FINISH, USI 3MM DEAD ZONE REQ'D BOTH SIDES,
SAWED ({ P/N 091757-5 }). PER AMS-QQ-A-250/12 PER AMS-STD-
2154 ((MARKED)) NOT INTERLEAVED MAX
GROSS SKID WGT: 8500 LB QUAN TOL +/-40 %
USI CL A 3 MM CQR 0156743 REV 01 CUST REQ 05-03-
31 *** W/E 05-04-02 ***

Num	Package Ticket	Lot	Weight	Quantity	UOM	Pc Id/Serl
1	261732	323111	4012	2	PC	

Notes for CQR: 0156743.1

PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF AMS-QQ-A-250/12 ALSO MEETS THE REQUIREMENTS OF QQ-A-250/12F. PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF QQ-A-250/12F ALSO MEETS THE REQUIREMENTS OF AMS-QQ-A-250/12. PRODUCT PRODUCED TO THE REQUIREMENTS OF MIL-STD-2154 ALSO MEET THE REQUIREMENTS OF AMS-STD-2154. PRODUCT PRODUCED TO THE REQUIREMENTS OF AMS-STD-2154 ALSO MEET THE REQUIREMENTS OF MIL-STD-2154.

CQR: 0156743.1 -Specification Limits

Temp	Dir	UTS KSI	TYS KSI	EL4D PCT
T7351	Long Transv.	Max	63.9	
		Min	66.0	6
T7351	Elec. Cond. (EC) % MIN	38.0 PCT		

Chemical Composition	SI	FE	CU	MN	MG	CR	ZN	TI	Other Each	Other Total	Aluminum
Alloy 7075	Max	.40	.50	2.0	.30	2.9	.28	6.1	.20	.05	.15
	Min			1.2		2.1	.18	5.1			REMAIN

Lot: 323111 -Mechanical, Physical, Metallography, Quantometer Results

Temp	Dir	No. Test	UTS KSI	TYS KSI	EL4D PCT
T7351	Long Transv.	3	Max	72.1	61.2
			Min	70.7	59.8

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PITTSBURGH, PA DAVENPORT WORKS

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Alcoa No. Item

DS-86515-1

Page 2

Lot: 323111 - Mechanical, Physical, Metallography, Quantometer Results (cont.) -----
T7351 Elect Cond %IACS 40.1 40.9 40.2 PCT

Cast Number	Chemical	SI	FE	CU	MN	MG	CR	ZN	TI
H9736052	Actuals	.08	.27	1.6	.03	2.5	.19	5.7	.02